

Date: Tuesday, 12/18/2007 10:46:21 AM  
 User: Kim Johnston

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 36403-2  
 Estimate Number : 12363  
 P.O. Number :  
 This Issue : 12/18/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : SMALL /MED FAB  
 Previous Run : 34461  
 Part Number : D34846  
 Drawing Number : D3484 UNDER REVIEW  
 Project Number : N/A  
 Drawing Revision : D  
 Material :  
 Due Date : 1/20/2008 Qty: 6 Um: Each  
 Written By :  
 Checked & Approved By : [Signature] 01.12.18  
 Comment : Est Rev: A New Issue 06-04-11 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.2904 sf(s)/Unit Total: 2.3234 sf(s)  
 6061-T6 .050 Sheet  
 (M6061T6S050)  
 Batch: 104186 B07-12-20

(10)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 Cut as per Dwg D3484

D  
B07-12-20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B07-12-20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 07/12/20 x 10

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur






2-Roll as per Dwg D3484

EF 08/12/16

(3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D34846 PAR #: N/A Fault Category: Prod / Mat & Small NCR: Yes No DQA: D Date: 09/01/06  
D3484-012 D412-750-142 QA: N/C Closed: D Date: 09/01/06

NCR: <u>36403</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/14	5	3 scrap NO J's R.C. process.		Scrap + destroy	 08/12/16	 08/12/16	 08/12/16	 08/12/16

NOTE: Date & initial all entries



Date: Tuesday, 12/18/2007 10:46:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 36403

Part Number: D34846

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Socheli 7 @*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Sawa P.*

*MF 08-01-08*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Dorbell 06*

Job Completion



*MF 09-01-06*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

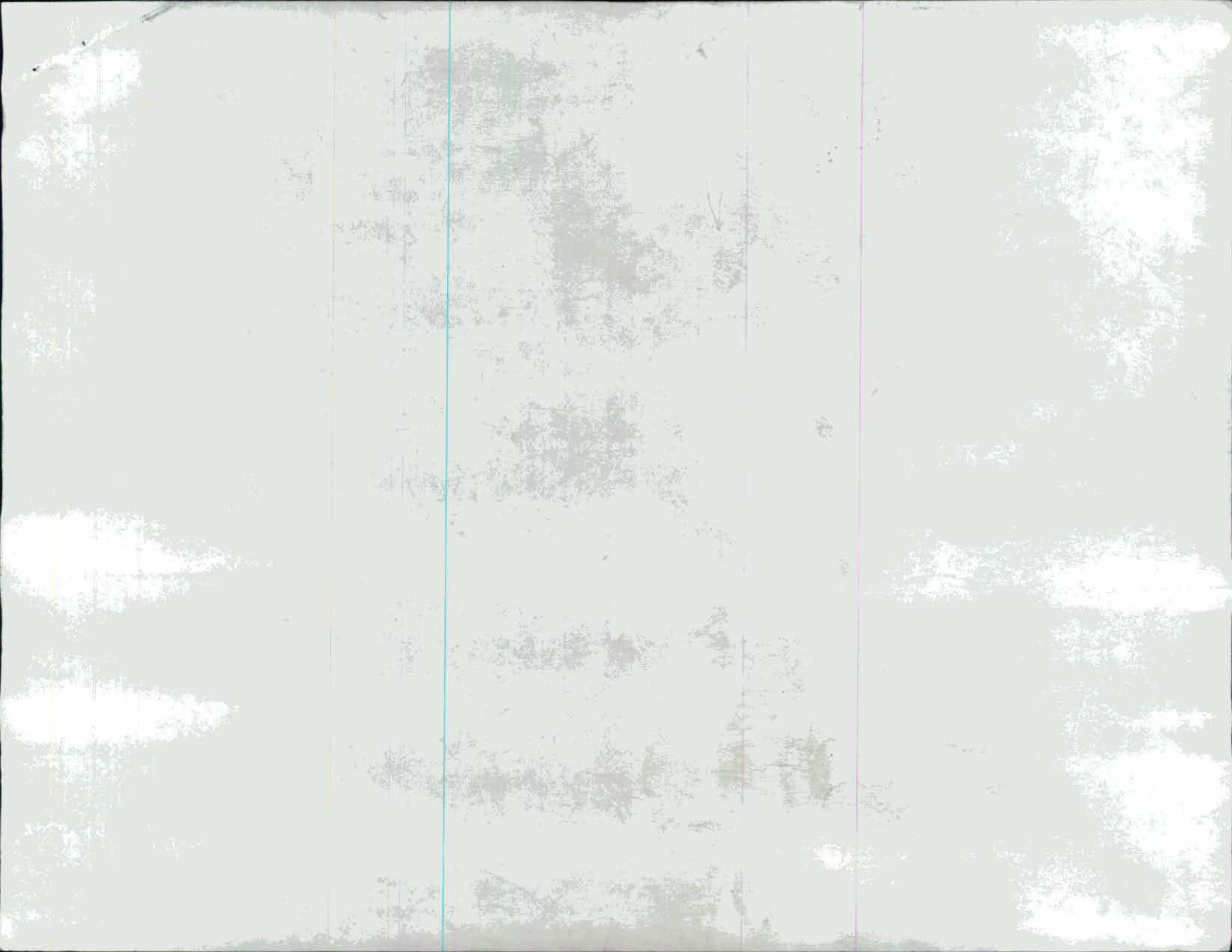
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







**DART**  
UNDER REVIEW

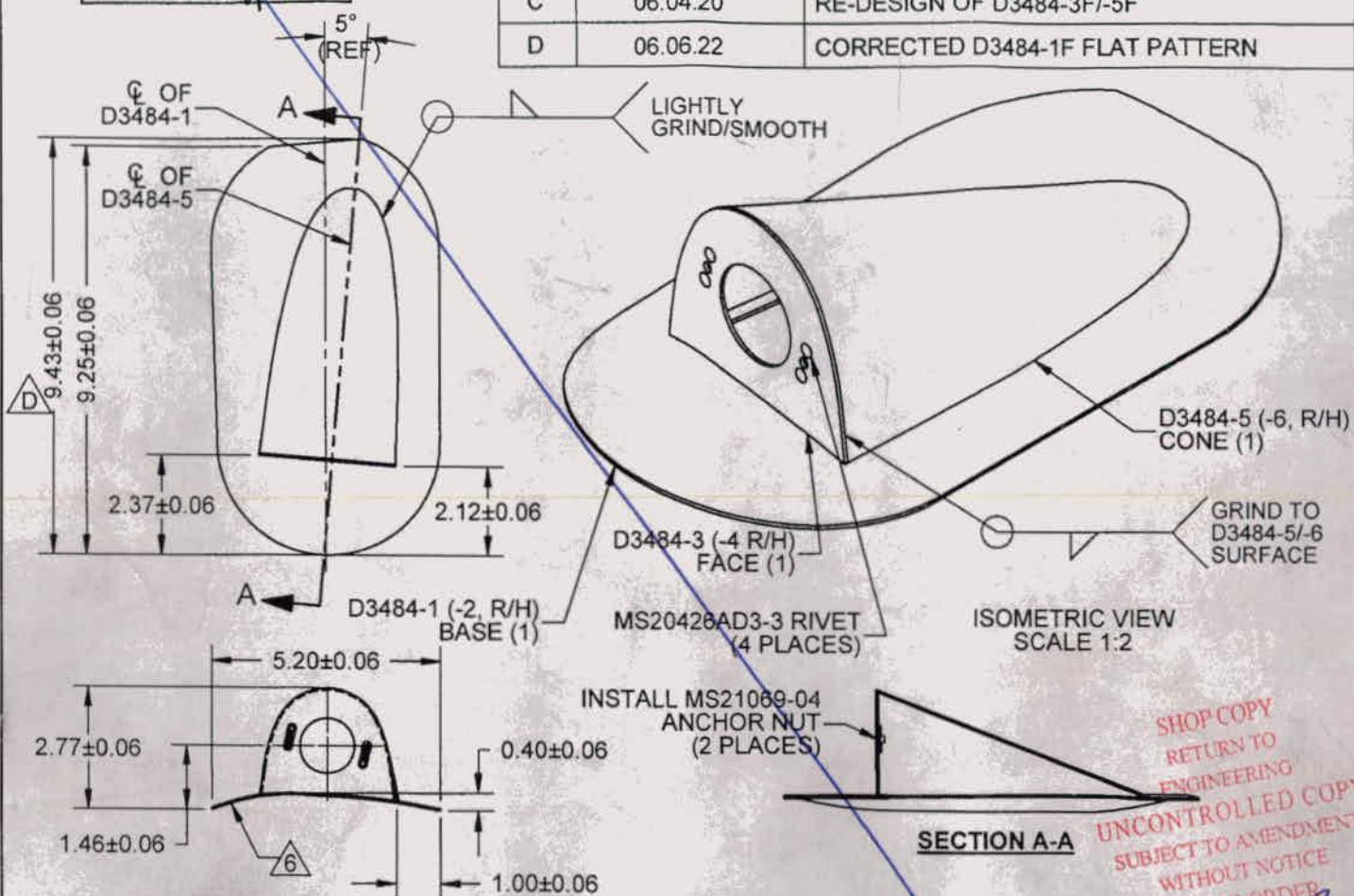
07.12.04

TO CLASSIFY DART (LH+RH)

**RELEASED**

06.08.17

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE	06.06.22	TITLE TAIL LIGHT FAIRING	SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	



**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)**

**NOTES:**

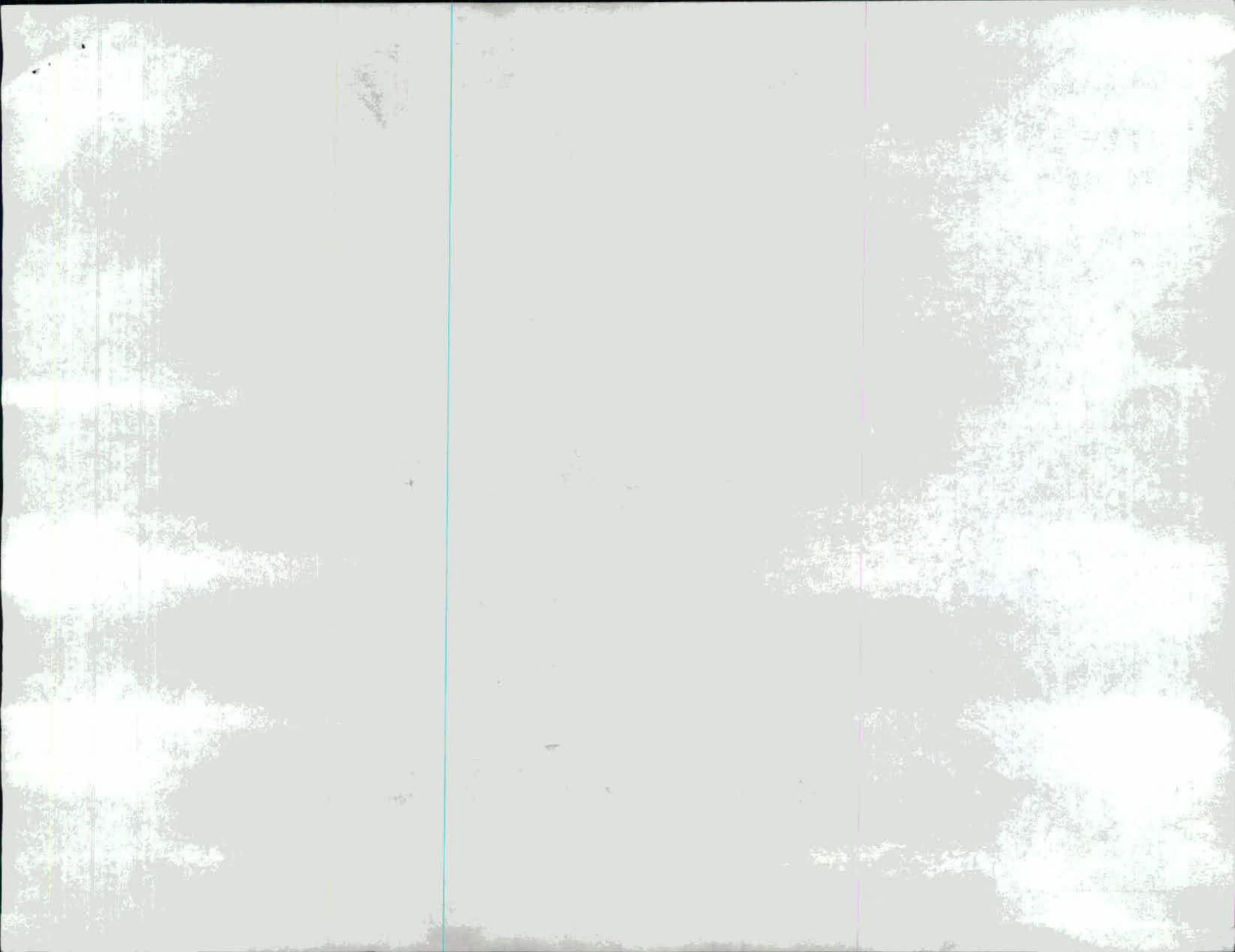
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD.,  
P/N D412-750-141/-142 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE  
PDA06-13"

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

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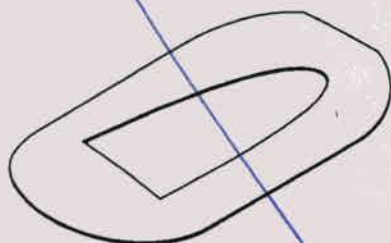




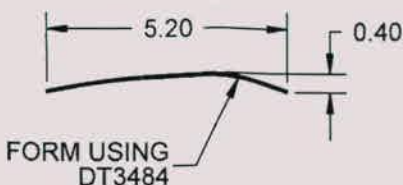
**DART**  
UNDER REVIEW

02.12.04 JB

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3484	REV. D SHEET 2 OF 4
DATE 06.06.22		TITLE TAIL LIGHT FAIRING	SCALE 1:2



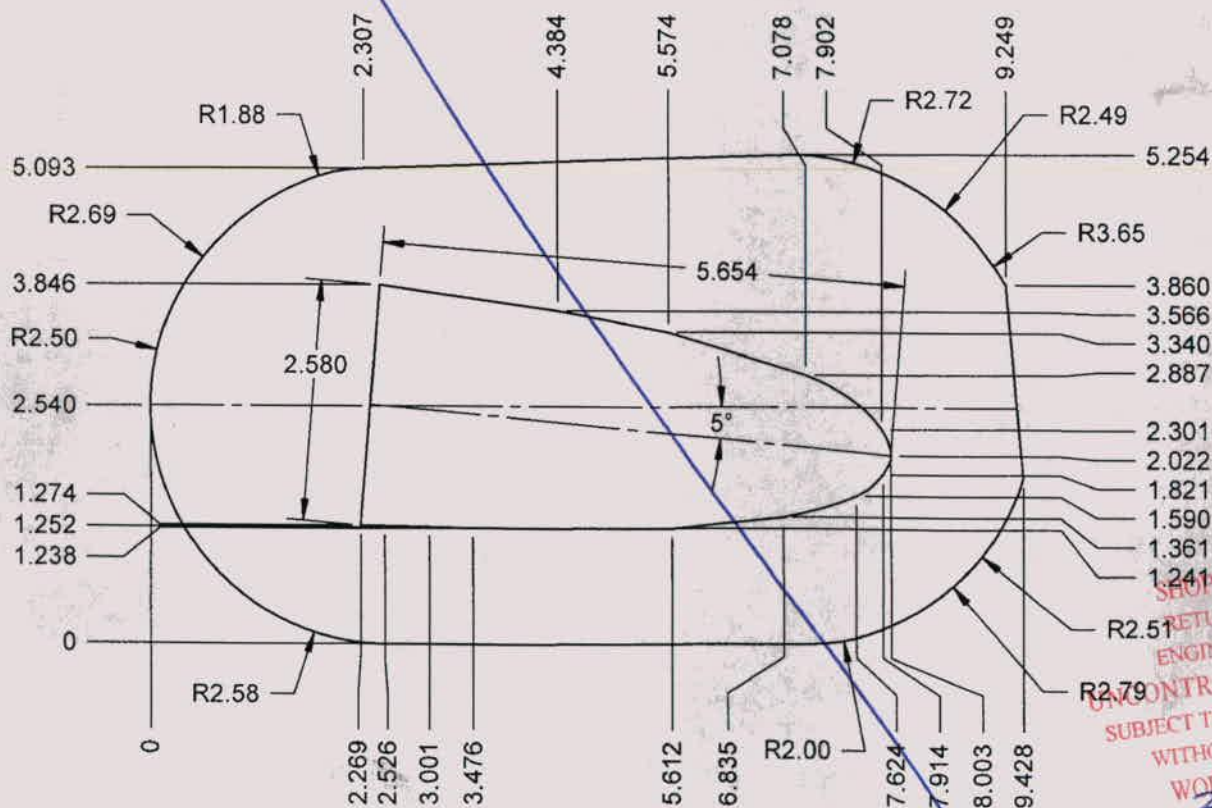
**D3484-1 BASE, L/H**



**D3484-1 BENDING DETAIL**  
(D3484-2 OPPOSITE)  
(MAKE FROM D3484-1F)



**D3484-2 BASE, R/H**



**D3484-1F BASE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

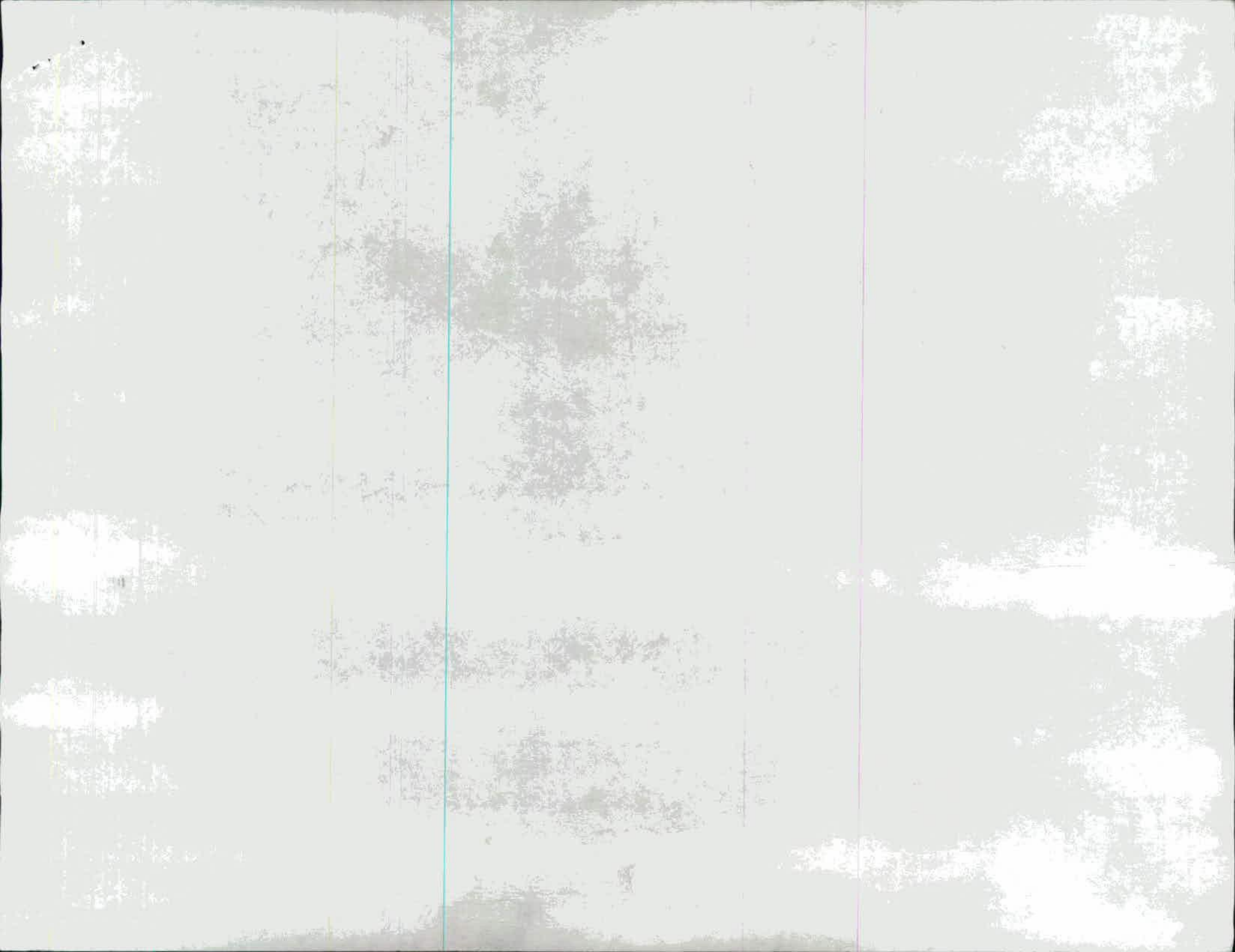
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06.08.17 H

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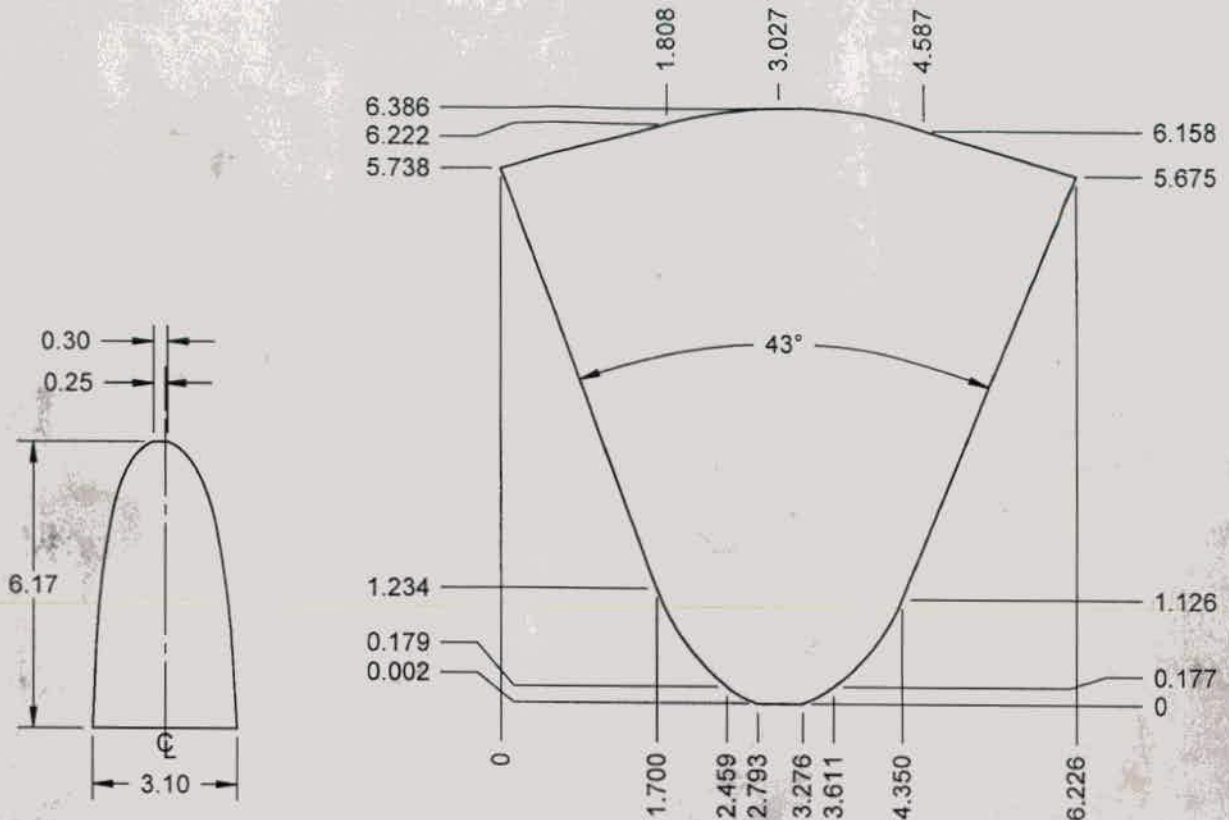
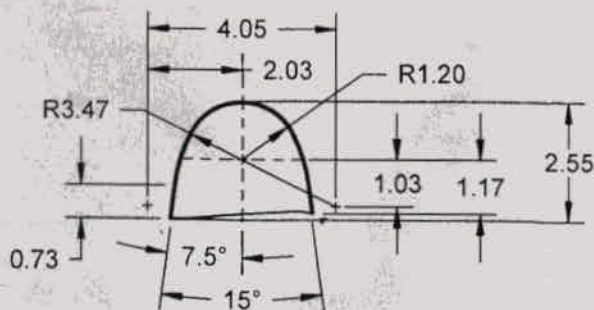






**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3484	REV. D SHEET 4 OF 4
DATE 06.06.22	TITLE TAIL LIGHT FAIRING		SCALE 1:4

**D3484-5F CONE FLAT PATTERN****D3484-5F CONE BENDING DETAIL (-6 R/H, OPPOSITE)  
(MAKE FROM D3484-5F)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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